

Date: Tuesday, 19/08/2008 4:03:46 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DECK PLATE,FWD ,350 LITTER KIT		
Job Number	: 41423					
Estimate Number	: 11104					
P.O. Number	:			Part Number	: D2364	
This Issue	: 19/08/2008	S.O. No. :		Drawing Number	: D2364 REV.F	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	Drawing Revision	: F	
Previous Run	: 39239			Material	:	
Written By	:			Due Date	: 08/09/2008	
Checked & Approved By	<u>JUL 08.8.9</u>			Qty:	6	
Comment	: EST. REV. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now On Waterjet 06-07-03 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		Comment: Qty.: 0.6792 sf(s)/Unit Total : 4.0755 sf(s) 2024-T3 .063 Aluminum sheet (M2024T3S063) Batch: <u>108415</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2364 Dwg Rev: <u>F</u> Prog Rev: <u>F</u>	 <u>HB 8-8-22</u> <u>7</u>
		2-Deburr if necessary	 <u>HB 8-8-22</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 <u>HB 8-8-22</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	 <u>S 08/09/25</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	 1- counter sink holes as per dwg D2364

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 41423

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- deburr if necessary

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/09/23 (7)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(7X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-f

08/09/26

8.0 POWDER COATING

POWDER COATING



(7X)

M105642

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8:10  
0F

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320  
8:40

m-f 08/09/27

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 08/09/29

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 186

R P 08/09/29 (7)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 (7)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	41423
Description: Litter Deck Plate Kit (350)		Part Number:	D2364
Inspection Dwg: D2364	Rev: F		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.631	X			
Ø0.171	+0.005/-0.000	172	X			
0.354	+/-0.010	356	X			
11.242	+/-0.010	11.240	X			
3.031	+/-0.010	3035	X			
1.903	+/-0.010	1.905	X			
1.128	+/-0.010	1.129	X			
0.354	+/-0.010	357	X			
1.340	+/-0.005	1.347	X			
2.326	+/-0.010	2.329	X			
3.312	+/-0.010	3.317	X			
4.298	+/-0.010	4.298	X			
5.284	+/-0.010	5.284	X			
6.151	+/-0.010	6.155	X			
6.270	+/-0.010	6.273	X			
0.354	+/-0.010	356	X			
3.031	+/-0.010	3.035	X			
Ø0.656	+0.005/-0.000	657	X			
5.003	+/-0.010	5.003	X			
4.605	+/-0.010	4.606	X			
1.776	+/-0.010	1.778	X			
0.980	+/-0.010	983	X			
4.487	+/-0.010	4.488	X			
7.192	+/-0.010	7.195	X			
7.567	+/-0.010	7.567	X			
7.942	+/-0.010	7.950	X			
Ø0.191	+0.005/-0.000	193	X			
Ø0.197	+0.005/-0.000	198	X			
11.145	+/-0.010	11.145	X			
12.181	+/-0.010	12.181	X			
11.378	+/-0.010	11.378	X			
11.776	+/-0.010	11.776	X			
12.173	+/-0.010	12.173	X			
4.690	+/-0.010	4.695	X			
0.250	+0.005/-0.000	251	X			
3.141	+/-0.010	3.149	X			
0.171	+0.005/-0.000	173	X			

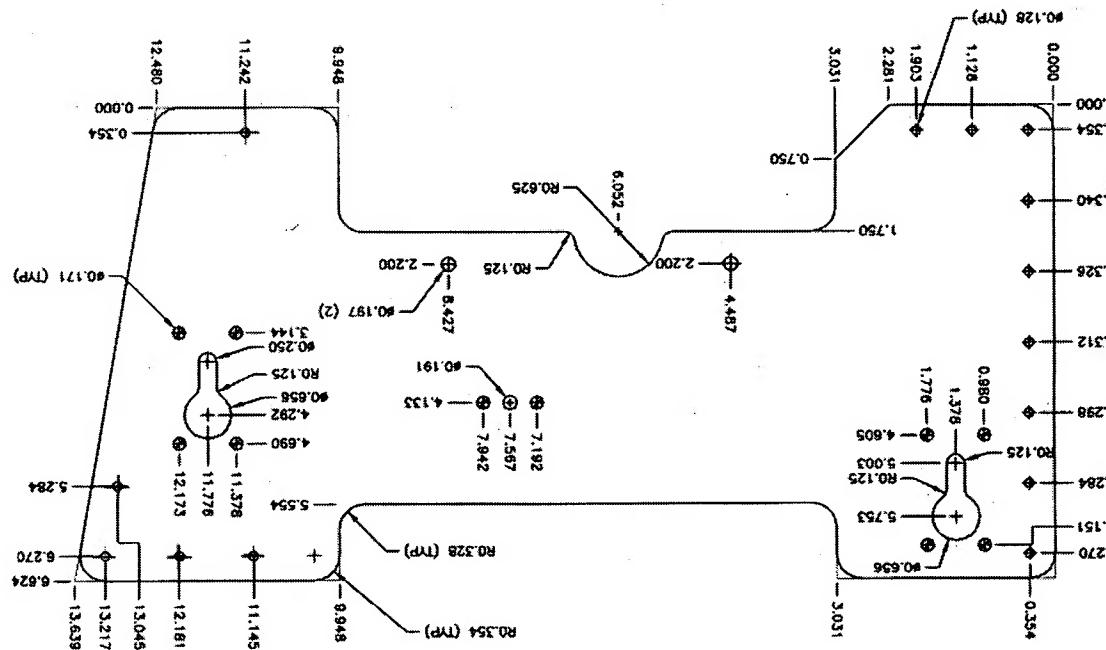
Measured by:	HB	Audited by:		Prototype Approval:	N/A
Date:	8-8-26	Date:	080826	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	

DRAWN BY <i>KF</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
APPROVED <i>JK</i>	REV. F	DRAWING NO. D2364	SCALE 2:5	SHEET 1 OF 1
DATE 98.06.19	TITLE LITTER DECK PLATE, 350			
A	95.01.14	NEW ISSUE		
B	95.02.09	MOVED KEYWAY		
D	95.03.06	0.191 WAS 0.197		
E	95.10.06	GEOMETRY CHANGES		
F	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)		

RECEIVED  
93/06/22  
K5

COUNTER SINK HOLES: C\_SINK 00.225 x 100. (UPDATERD FROM 9 TO 14 HOLES FOR OS 99.03.01 TO CORRECT CAD ERROR) C\_SINK 00.308 x 100.



MATERIAL: 2024-T3 (00-A-250/5) 0.063-0.071 THICK  
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 123456

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